

Work Order ID 102795-2

102795

Page 1

June-12-13 9:14:15 AM

Item ID: 647.9613 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: RH Aft Wiper Deflector
 Start Date: 6/11/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 6/11/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 130612 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.9600	N/C								

110 0.00

110

Outsource5

Outsource process - Machining

Memo

ISSUE P/O: 26439
 POSSIBLE SUPPLIER: ARCHER PRECISION

Certificate of conformaty required

CZ 13/07/05 (10)

115 Receive & Inspect for Damage & Mat'l Certs 0.00

115

Packaging

Packaging

Memo

143/4/13 (10)

117 QC6- Inspect dimensions to drawing 0.00

117

QC

Quality Control

Memo

DAS
 27
 9-89

139.13

10

Work Order ID 102795

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Page 2

Item ID: 647.9613

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: RH Aft Wiper Deflector

Start Date: 6/11/13 Start Qty: 10.00

10

Required Date: 6/11/13 Req'd Qty: 10.00

10

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

118

0.00

118

HandFinish

Memo

0.00

Hand Finishing

REMOVE ALL PART MARKINGS

N/A

120

Outsource process-Anodize per QSI017 4.1.10.1

0.00

120

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG : 21431

1- Black Anodize as per Dwg 647.9600

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

CZ 13/09/20 @

130

Receive & Inspect for Damage & Mat'l Certs

0.00

130

Packaging

Memo

0.00

Packaging

13/11/18 @

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June-12-13 9:14:15 AM

Item ID: 647.9613

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: RH Aft Wiper Deflector

Start Date: 6/11/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: ST418

0.00

170

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

6

DAS
28
9-89

6x

13-10-18

13-10-21

13-10-21

Picklist Print

June-12-13 9:14:15 AM

Page 1
1

Work Order ID: 102795
Parent Item: 647.9613
Parent Item Name: RH Aft Wiper Deflector

Start Date: 6/11/13 Required Date: 6/11/13
Start Qty: 10.00 Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12-11-19 JLM VERIFIED BY:DD

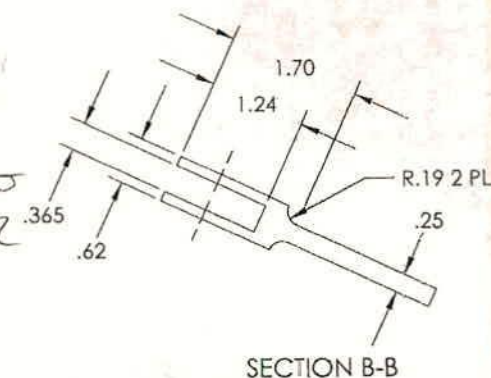
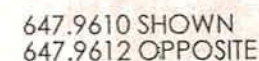
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.9613P RH Aft Wiper Deflector		Purchased	No				Each	0.0000		10		6/3/13	(10)
M7075T6B6.000X6.000 7075-T6 BAR 6.000' X 6.000" (order in billets)		Purchased	No				f	4.8640		6.357895			

Location	Loc Qty	Loc Code
MAT001	4.864	
124393	4.864	

4.864 - 13/06/18

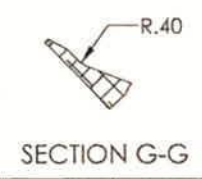
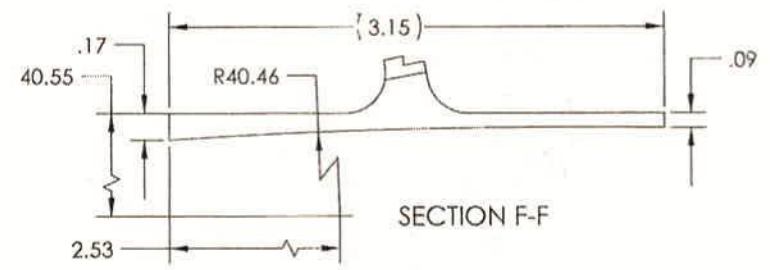
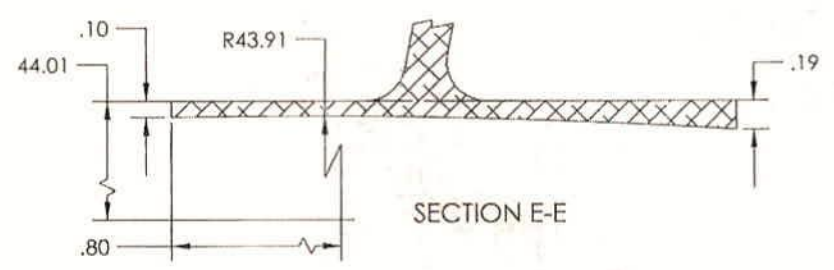
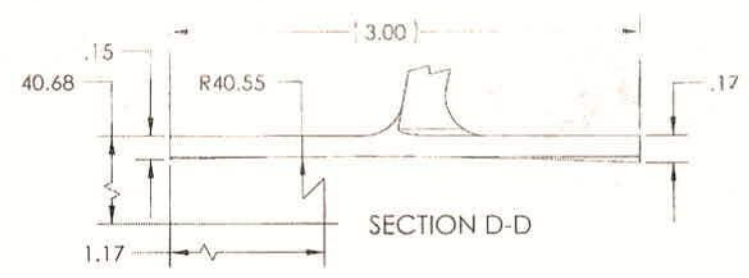
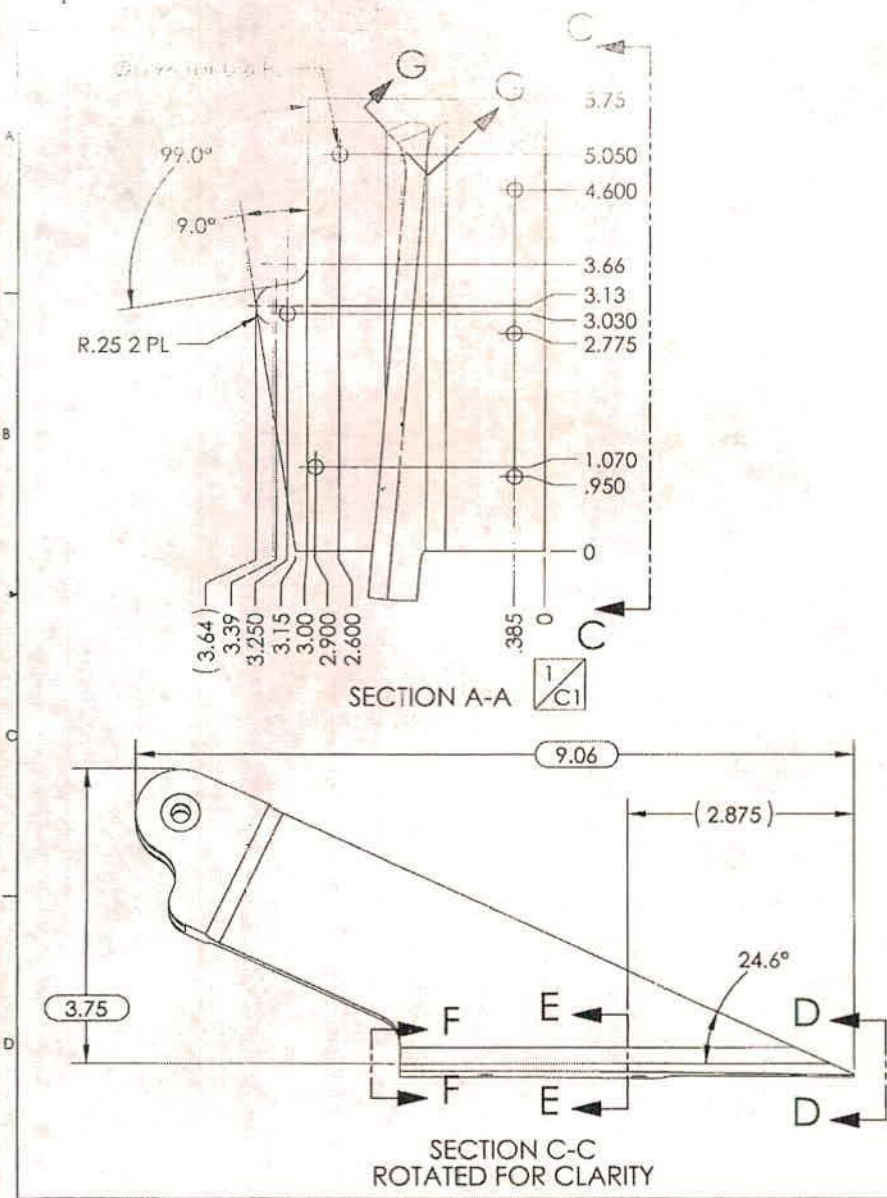
M/26133 x 2 pcs. CL13107104

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: ANODIZE PER MIL STD-A-8625, TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. PART DIMENSIONS CONTROLLED BY CAD MODEL
FILE NAME: 647.9610 NC LH FWD WIPER DEFLECTOR.SLDPRT, LAST MODIFIED 06/30/10.
4. PART DIMENSIONS CONTROLLED BY CAD MODEL
FILE NAME: 647.9611 NC LH AFT WIPER DEFLECTOR.SLDPRT, LAST MODIFIED 06/30/10.
5. PART DIMENSIONS CONTROLLED BY CAD MODEL
FILE NAME: 647.9612 NC RH FWD WIPER DEFLECTOR.SLDPRT, LAST MODIFIED 06/30/10.
6. PART DIMENSIONS CONTROLLED BY CAD MODEL
FILE NAME: 647.9613 NC RH AFT WIPER DEFLECTOR.SLDPRT, LAST MODIFIED 06/30/10.
7. DEBURR AND BREAK ALL SHARP EDGES.
8. IDENTIFY IAW MPP-120. LASER ETCH P/N REVISION, 12 PT. CENTURY GOTHIC.



		247.9613	RH AFT WIPER DEFLECTOR	△	△	△	△
		247.9612	RH FWD WIPER DEFLECTOR	△	△	△	△
		247.9611	LH AFT WIPER DEFLECTOR	△	△	△	△
		247.9610	LH FWD WIPER DEFLECTOR				
1	1						
	FIND						
	#	PART #	DESCRIPTION	MAT'L	SPEC.		
QTY			PARTS LIST				
NEXT ASSY (S)				APICAL INDUSTRIES			
247.8900				2608 TEMPLE HEIGHTS CBL OCEANSIDE, CA. 92056-3512 (760) 724-5300			
ORIGINAL DATE: _____ CHECKED BY: _____ DRAWN BY: _____ L. JACKSON IN WAGON APPROVAL: _____ CONTRACT NO. 83				WIPER DEFLECTOR 647-9600			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/2 PLACE DECIMALS ±0.13 ANGLES ± 1°				SH# 07/24/86 SCALE NONE	DWG. NO. 647-9600	REV. N/A	
				SHEET 1	OF 5		

102795

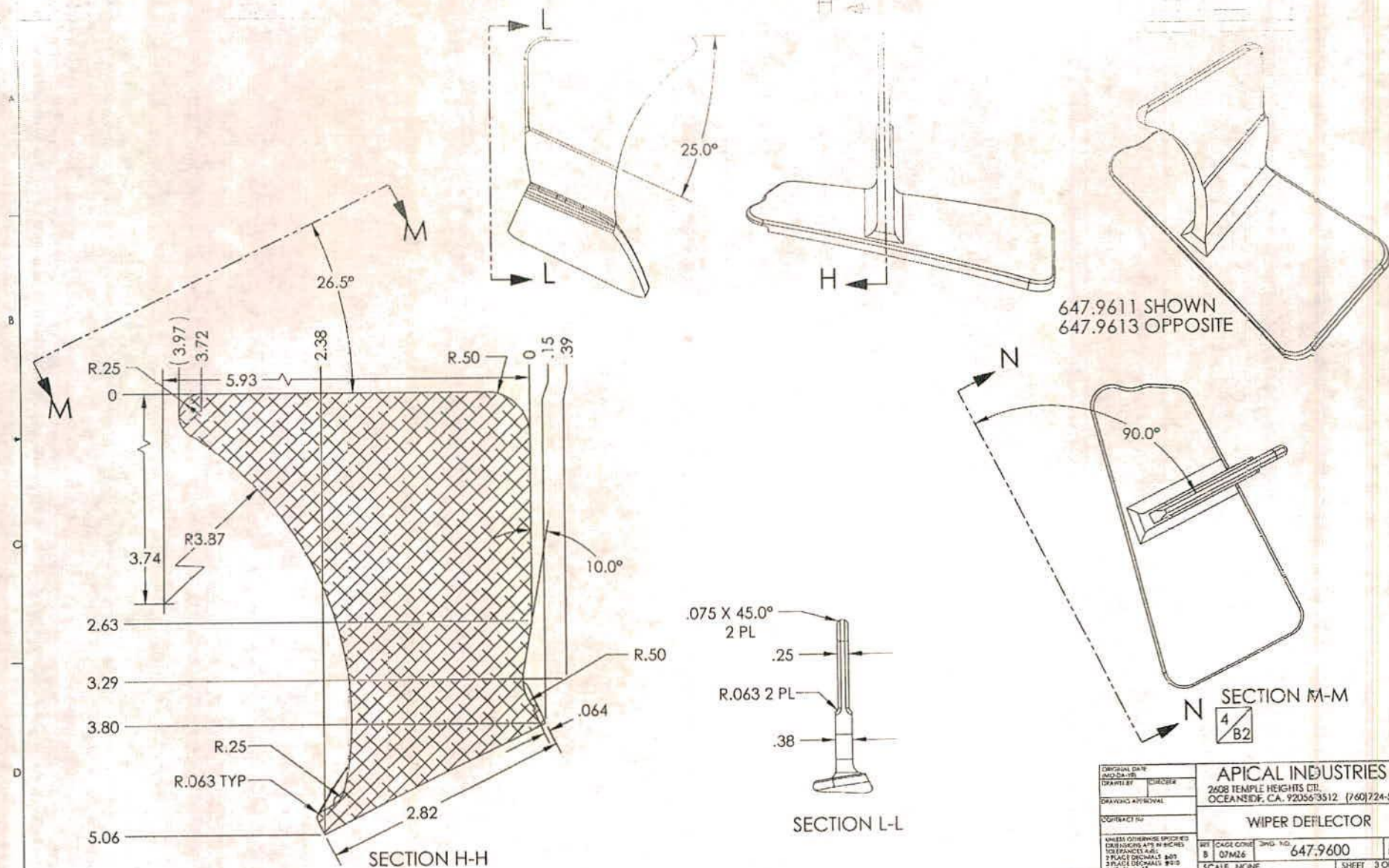


ORIGINAL DATE	07/12/06	DESIGNED BY	CHECKED BY
DRAWING APPROVAL		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°			
REV	07/12/06	DATE	647.9600
SCALE	NONE	SHEET	2 OF 5

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

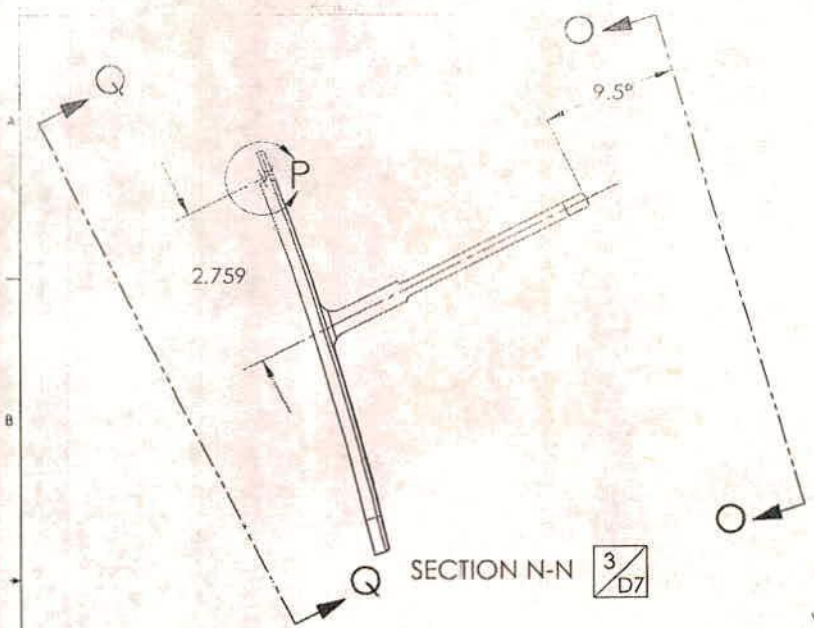
W/PER DEFLECTOR

102791

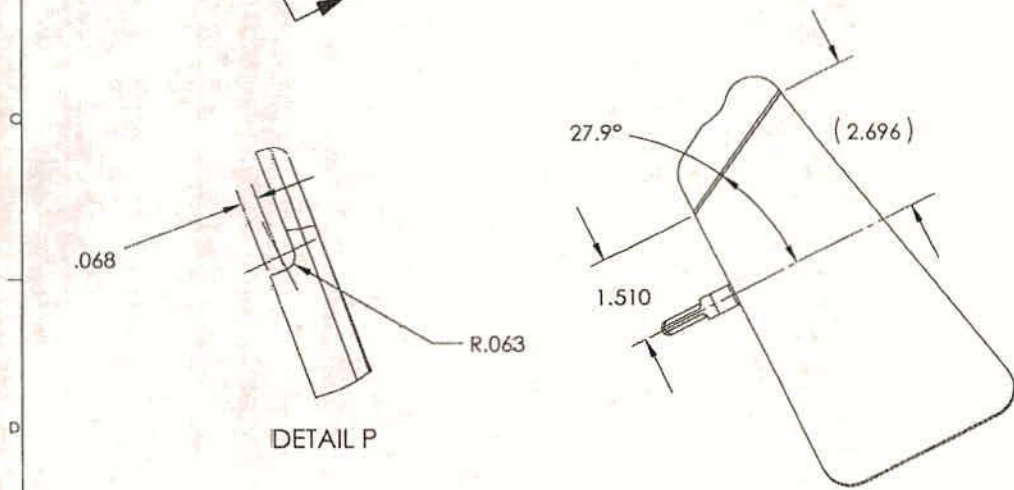


ORIGINAL DATE (MM-DD-YY)		APICAL INDUSTRIES	
DRAWN BY		2608 TEMPLE HEIGHTS CT.	
DRAWING APPROVAL		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
COUNTERPART NO.		WIPER DEFLECTOR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS .005 2 PLACE DECIMALS .010 ANGLES ± .5°		REV. NO. 647-9600	REV. N/C
SCALE: NONE		SHEET 3 OF 5	

102798

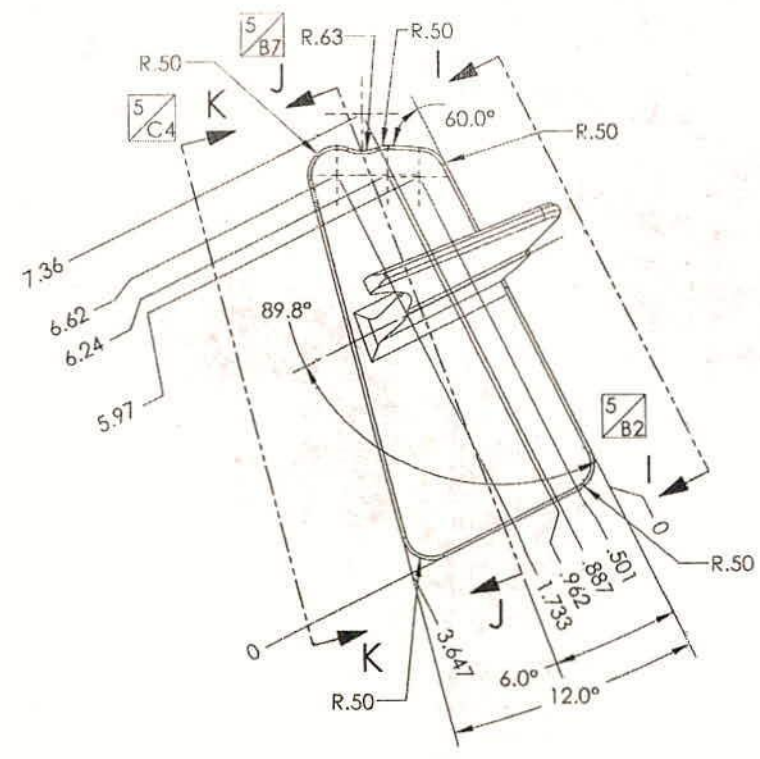


SECTION N-N 3
D7



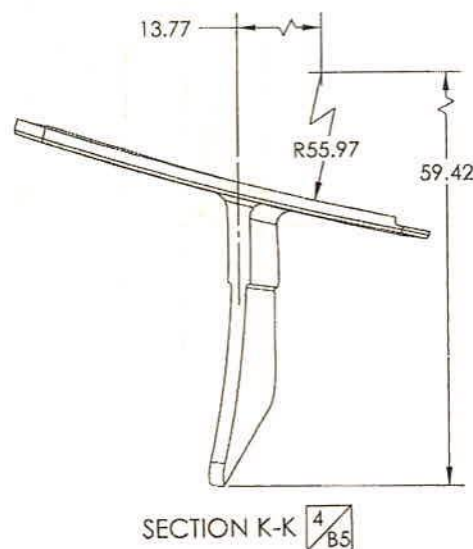
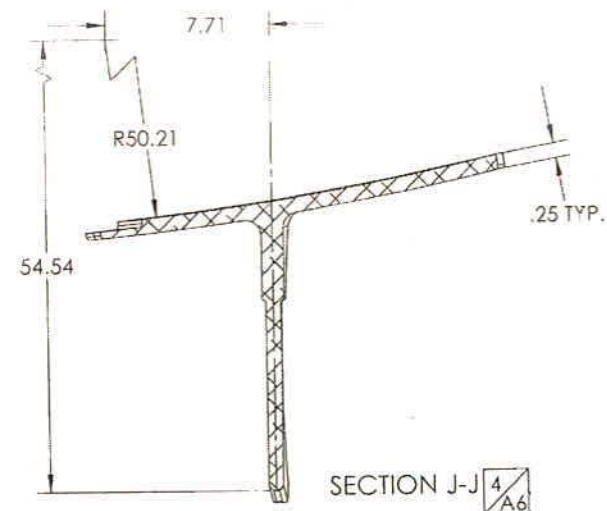
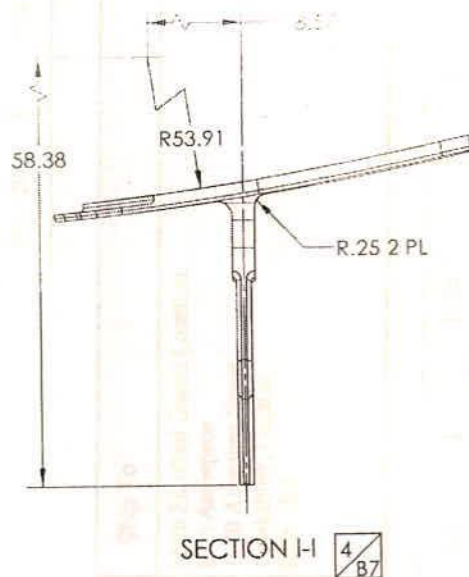
DETAIL P

SECTION Q-Q



SECTION O-O

ORIGINAL DATE		APICAL INDUSTRIES	
DRAWN BY		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL		OCEANSIDE, CA 92056-3512 (760) 724-5300	
COORDINATE FILE		WIPER DEFLECTOR	
UNLESS OTHERWISE SPECIFIED		SEE (CASH DETAIL)	QTY: 142
DIMENSIONS ARE IN INCHES		B 07M20	647.9600
TOLERANCES ARE:		SCALE: N/C	SCALE: N/C
1 PLACE DECIMALS ± .01			
2 PLACE DECIMALS ± .005			
3 PLACE DECIMALS ± .001			
ANGLES ± .5°			
		SHEET	4 OF 5



ORIGINAL DATE: 10/25/00		APICAL INDUSTRIES	
MODIFIED: 10/25/00	DRAWN BY: J. HICKS	2608 TEMPLE HEIGHTS DR.	
DESIGNED BY: J. HICKS	CHECKED BY: P. BEAVO	OCEANSIDE, CA. 92036-3512 (760) 724-4300	
DRAWING APPROVAL: P. BEAVO	CONTRACT NO.:	WIPER DEFLECTOR	
SHEETS OTHERWISE SPECIFIED		REV.:	REV.:
DIMENSIONS ARE IN INCHES		DATE: 07/26/00	DATE: 07/26/00
1/4" PLATE DIMENSIONS & 1/4"		SCALE: NONE	SHEET: 5 OF 5
ANGLES & 5°			



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

11 September 2013

Po Number	Part Number	Quantities
20439	647.9613	14

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 20439 issued by Dart Aerospace Inc.

Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62691

Date: 18-Oct-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 11 PCS 647.0114 (7.95\$EA) 10 PCS 647.0115 (7.95\$EA) 10 PCS 647.9613 (16.30\$EA) <i>YTG</i> HARD BLACK ANODIZE MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130649 PO: 21431	Rev:	Line:
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>18/10/13</u></p> <p>CERTIFIED SIGNATURE: <u><i>[Signature]</i></u></p> <p>RECEIVER SIGNATURE: _____</p>			